

Date: Tuesday, 11/29/2005 7:11:18 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 25056
 Estimate Number : 10383
 P.O. Number : N/A
 This Issue : 11/29/2005 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : N/A
 Written By : RF/KJ
 Checked & Approved By :
 Comment : Created By Auto Work Order!!! Late - Some of the material cannot be made in time. Rev C. 02-11-01

Drawing Name : SPACER
 Part Number : D30661
 Drawing Number : D3066 REV. A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 11/29/2005 Qty: 120 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M5052H32S080

5052-H32 .080 Sheet



Comment: Qty.: 0.0992 sf(s)/Unit Total: 11.9070 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.080" thick
(M5052H32S.080)Batch: M19052

140 pcs

Tools:

2.0

SHEAR

SHEAR



Comment: SHEAR

Cut blank: 16.490" x 0.750" -0.000/+0.010"

J.L 05-12-12 140

Tools:

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA280 and Dwg D3065

Stack of 10

Identify as D3066-1

J.L 05-12-15 120

Tools:

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 05-12-15 120

Tools:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3066-1 PAR #: _____ Fault Category: Prod / machined parts NCR: Yes No DQA: 13 Date: 05/12/21
 QA: N/C Closed: 13 Date: 05/12/21

NCR: <u>250526</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>05.12.14</u>	<u>3</u>	<u>- 3 stacks of 10 scrap</u>	<u>[Signature]</u> <u>05.12.14</u>	<u>- scrap + destroy</u> <u>- replace 1 stack of 10</u> <u>to complete order of 120</u>	<u>J.C</u> <u>05.12.14</u>	<u>[Signature]</u> <u>05.12.15</u>	<u>[Signature]</u> <u>05.12.15</u>	<u>[Signature]</u> <u>05.12.15</u>

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 7:11:18 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 25056

Part Number: D30661

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ML 05/12/15 120

Tools:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr Stack

Tools:

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 05/12/19 120

Tools:

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

Tools:

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SAD 05/12/20 120

Tools:

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: WA

205-12-20 120

Tools:

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

205-12-21 120

Tools:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

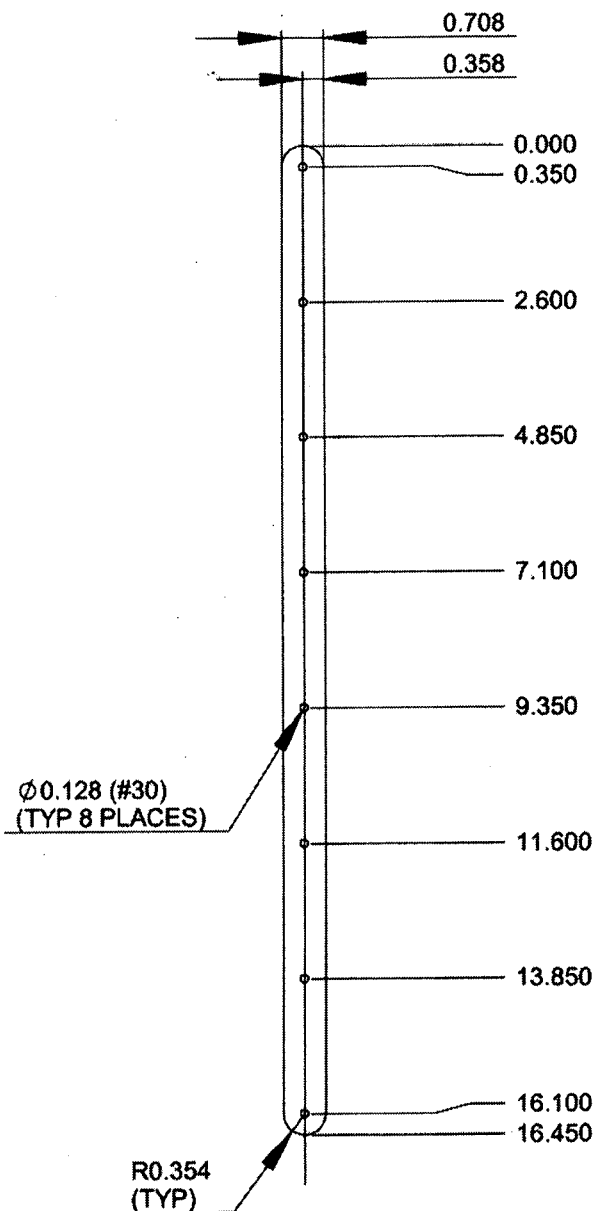
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3066	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3066-1 SPACER

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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